

SPECIAL PACKAGING INSTRUCTION					Form Approved OMB No. 0704-0188	
1. PART OR DRAWING NO. (CAGE) (NOMENCLATURE) 12375388 (19207) MOTOR ASSEMBLY			2. CODE INDENT 19207		3. SPI NO. AK13204744	
4. NATIONAL STOCK NO. 4320-01-320-4744			5. DATE OF DRAWING 4-12-94		6. REVISION P	
7. QUP 1 EA	8. ICQ NONE	9. UNIT PACK WT. (LB) 102.0	10. UNIT PACK CU (CU. FT.) 1.147		11. UNIT PACK SIZE (IN.) 16.0 X 11.8 X 10.5	
12. PRESERVATION		18. STEPS		20. DESCRIPTION		
a. LEVEL A MIL-P-116, METHOD I		1-B		PRESERVATIVE: MIL-L-2104, GR. 10.		
b. LEVEL B NOT APPLICABLE		2-C 2		CLOSURE: MIL-C-5501/7.		
13. CLEANING MIL-P-116, PROCESS C-1		3-D		PRESERVATIVE: MIL-C-16173, GR. 4.		
14. DRYING MIL-P-116		4-E 1		BAG: MIL-B-117, TYPE I, CL. B, SIZE: 2-1/2 X 3.		
15. PACKING		5-F 1		BLOCKING: A-A-55057.		
a. LEVEL A MIL-STD-2073-1 AND NOTE J		6-G 1		WRAP: MIL-B-121, TYPE II, GR. A, CL. 2, SIZE: 6 X 6.		
b. LEVEL B MIL-STD-2073-1 AND NOTE J		7-H 3		CUSHIONING: PPP-F-320, TYPE CF, CL. WR, VARIETY TW.		
16. MARKING MIL-STD-129		8-I 1		CONTAINER: PPP-B-640, TYPE CF, CL. WR, STYLE RSC, SIZE: 10-5/8 X 9-3/8 X 13-3/4.		
17. NOTES/DRAWING						
<p>A. QUALITY ASSURANCE PROVISIONS:</p> <p>1. INSPECT THE PRESERVATION AND UNIT PACK IN ACCORDANCE WITH MIL-STD-2073-1.</p> <p>2. INSPECT PACKING IN ACCORDANCE WITH MIL-STD-1186 AND APPLICABLE CONTAINER SPECIFICATION.</p> <p>B. FLUSH OR SLUSH INTERNALLY AND THOROUGHLY DRAIN EXCESS.</p> <p>C. PROTECT PORTS WITH TEMPORARY CLOSURES OF THE APPROPRIATE SIZE.</p> <p>D. APPLY PRESERVATIVE TO ALL UNPAINTED AND UNPLATED METALLIC SURFACES.</p> <p>E. PLACE ONE MS35756-21 WOODRUFF KEY IN BAG AND CLOSE BAG BY HEAT SEALING, STAPLES, OR TAPE. ATTACH BAG WITH KEY TO MOTOR ASSEMBLY USING TAPE WHERE IT WILL BE VISIBLE AND NOT INTERFERE WITH CUSHIONING REQUIREMENTS.</p> <p>F. FOR FABRICATION AND PLACEMENT OF BLOCK "A" SEE SKETCHES ON PAGES 2 AND 4.</p> <p>G. PLACE WRAP "B" ON BLOCK "A". PUNCH FIVE HOLES IN WRAP "B" TO LINE UP WITH HOLES IN BLOCK "A". SECURE MOTOR ASSEMBLY TO BLOCK "A" AND WRAP "B" USING FOUR 5/8-11UNC-2B X 3-1/2-INCH BOLTS AND APPROPRIATE LOCKWASHERS AND NUTS AS SHOWN IN SKETCH ON PAGE 4.</p> <p>H. FOR FABRICATION AND PLACEMENT OF CUSHIONING "C", "D", AND "E" SEE SKETCHES ON PAGES 3 AND 4.</p> <p>I. CLOSURE SHALL BE IN ACCORDANCE WITH CONTAINER SPECIFICATION.</p> <p>J. PACKING:</p> <p>LEVEL A PACKING SHALL BE ACCOMPLISHED USING CLEATED-PLYWOOD BOXES, OVERSEAS TYPE, CONFORMING TO PPP-B-601; OR NAILED WOOD BOXES CONFORMING TO PPP-B-621, CLASS 2.</p> <p>LEVEL B PACKING SHALL BE ACCOMPLISHED USING FIBERBOARD BOXES, WEATHER RESISTANT CLASS, CONFORMING TO PPP-B-636; OR TRIPLEWALL, CORRUGATED FIBERBOARD BOXES, CLASS 2, CONFORMING TO PPP-B-640; OR PALLET BASE CONTAINER, TYPE III, CONFORMING TO MIL-B-43666.</p> <p>WHEN THE TOTAL QUANTITY TO BE SHIPPED TO THE SAME DESTINATION EXCEEDS 125 POUNDS, LEVEL A AND LEVEL B EXTERIOR PACKS WITHOUT SKIDS SHALL BE PALLETIZED IN ACCORDANCE WITH MIL-STD-147.</p> <p>* NOTE: SIZE OF ITEM AND PACKING MATERIALS MAY VARY DUE TO TOLERANCES ON DRAWING.</p>						

SPECIAL PACKAGING INSTRUCTION (Continuation Sheet)

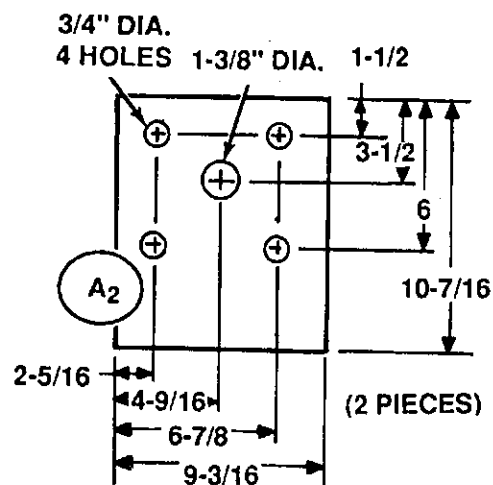
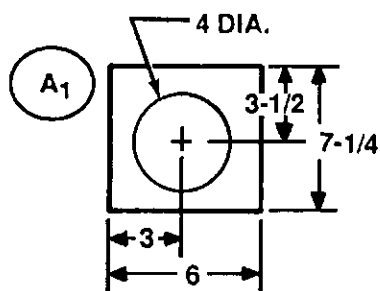
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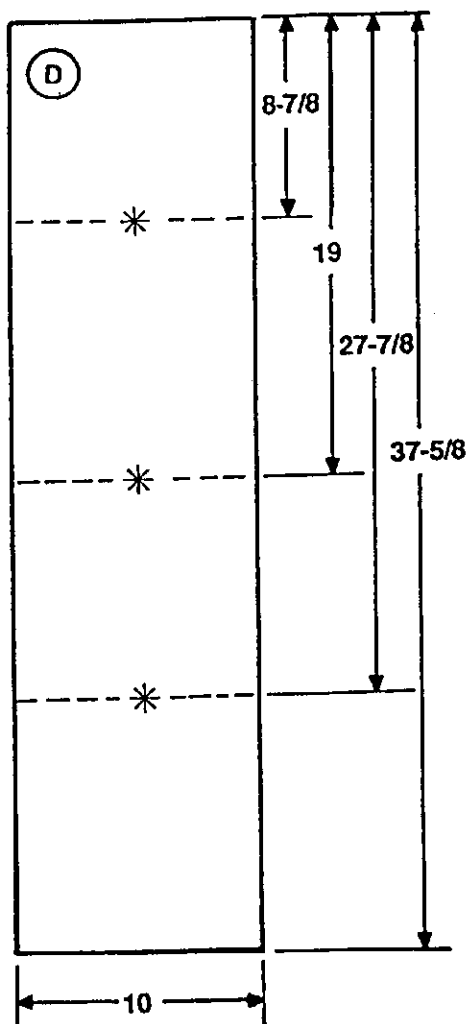
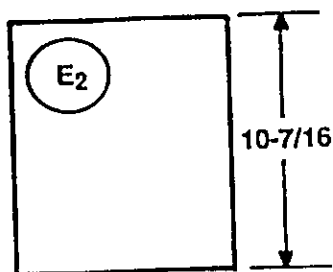
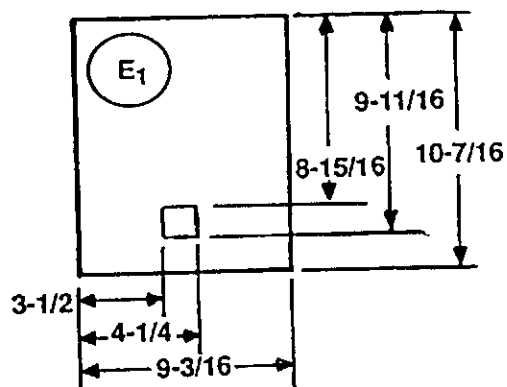
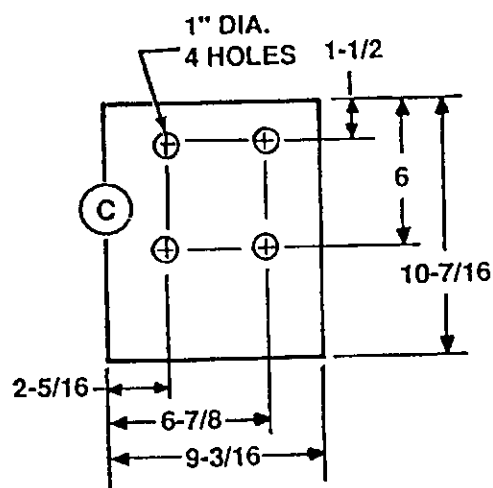
1. ALL DIMENSIONS ARE IN INCHES.
2. FABRICATE BLOCK "A1", USING PLYWOOD CONFORMING TO A-A-55057, EXTERIOR EXPOSURE CAPABILITY, 32/16 SPAN RATING, GRADE CDX, 1/2-INCH THICK AS SHOWN BELOW.
3. FABRICATE BLOCK "A2", TWO PIECES, USING PLYWOOD CONFORMING TO A-A-55057, EXTERIOR EXPOSURE CAPABILITY, 48/24 SPAN RATING, GRADE CDX, 3/4-INCH THICK AS SHOWN BELOW.
4. SECURE "A1" AND "A2", TWO PIECES, TOGETHER TO FORM BLOCK "A", ALIGN CENTER OF THE HOLE ON PAD "A1" WITH THE CENTER HOLE OF PADS "A2" AND SECURE USING FF-N-105 NUMBER 7 CEMENT COATED NAILS AS SHOWN ON PAGE 4. DRILL FOUR 3/4-INCH DIAMETER HOLES THROUGH BLOCK "A" USING BLOCK "A2" AS A TEMPLATE.



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NOTES:

1. ALL DIMENSIONS ARE IN INCHES.
2. FABRICATE CUSHIONING "C", "D", AND "E" USING VARIETY TW FIBERBOARD AS SHOWN IN THE SKETCH BELOW.
3. FABRICATE CUSHIONING "E" FROM PADS "E₁" AND "E₂" USING A GOOD QUALITY WATERPROOF ADHESIVE AS SHOWN IN THE SKETCH BELOW.
4. SECURE SLEEVE "D" USING TAPE.



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NOTES:

1. PAD "C" TO COVER BOLT HEADS AS SHOWN BELOW.
2. WOODRUFF KEY IN BAG NOT SHOWN FOR CLARITY.

